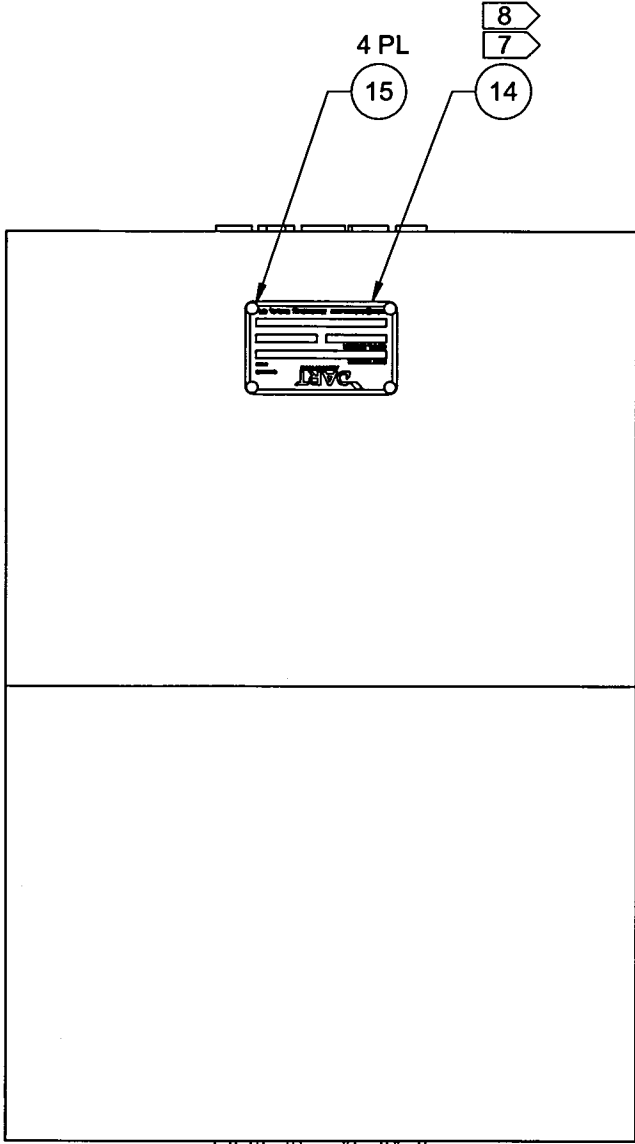
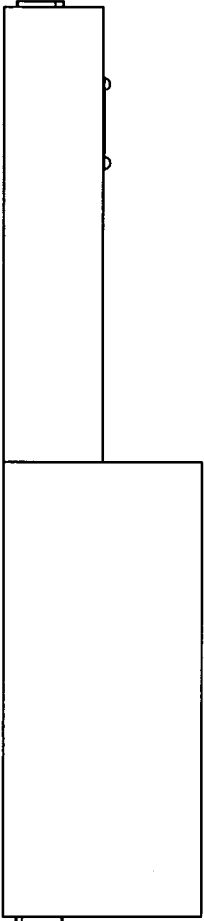
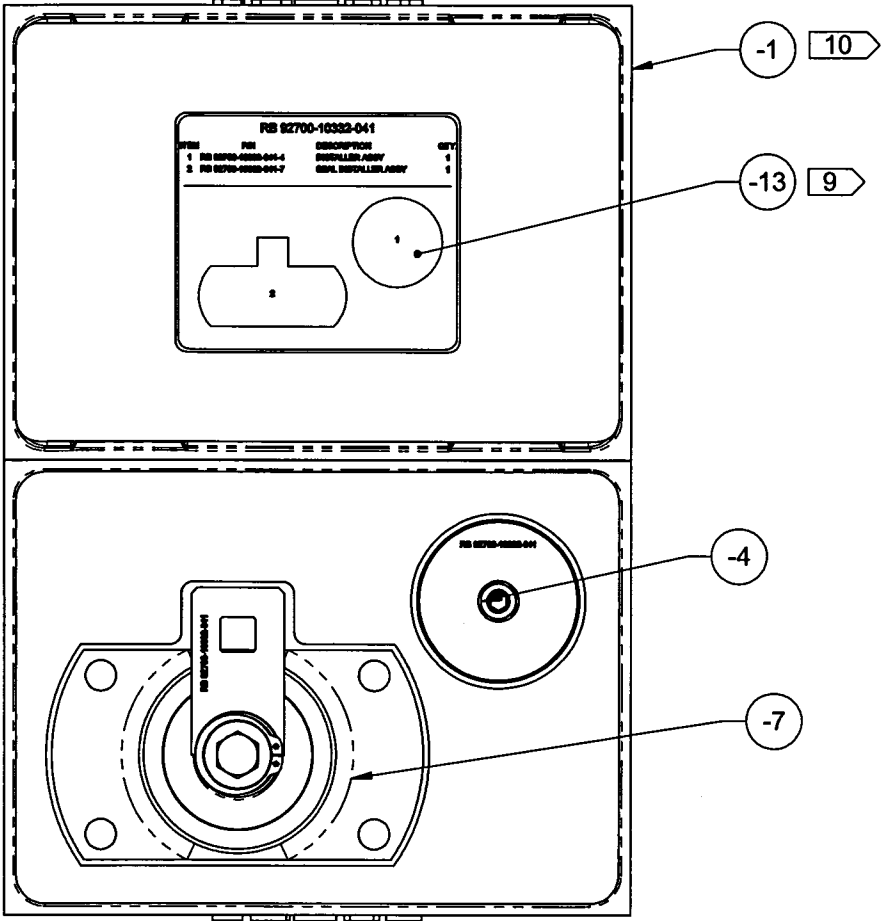


ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10332-041-1	PACKAGING ASSY
-4	1	RB 92700-10332-041-4	INSTALLER ASSY
-7	1	RB 92700-10332-041-7	SEAL INSTALLER ASSY
-13	1	RB 92700-10332-041-13	POSITION PLACARD
14	1	RB41011	DART PLACARD
15	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.

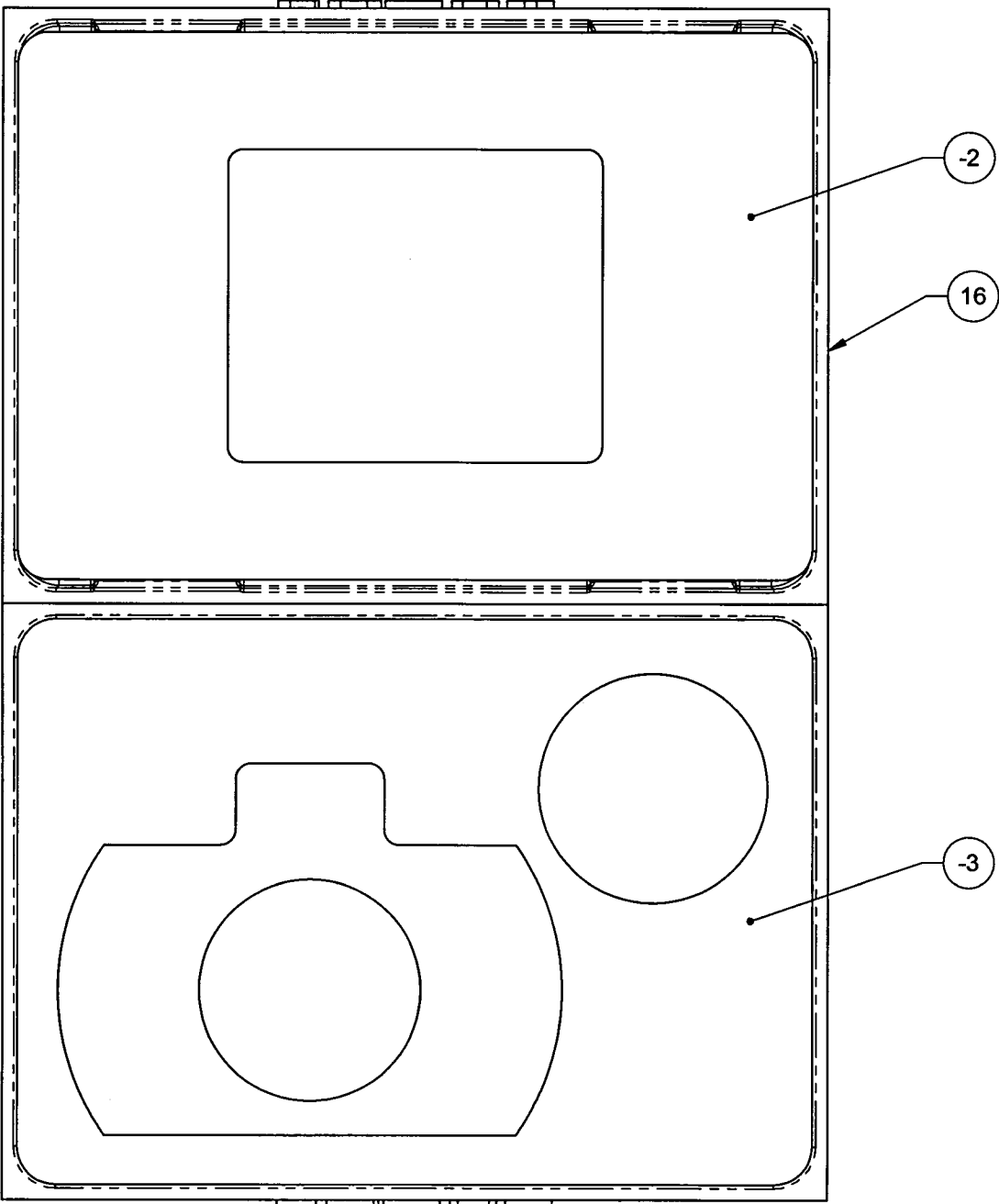


RB 92700-10332-041 HYDRAULIC PUMP SEAL TOOL SET

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
 - 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
 - 9) HOT GLUE THE PLASTIC PLACARD ONTO THE TOP FOAM
 - 10) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

A	NEW ISSUE	18-614	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10332-041	SHEET 1 OF 14
APPROVED	VM	TITLE	SCALE
DATE 9/12/2018		HYDRAULIC PUMP SEAL TOOL SET	NTS
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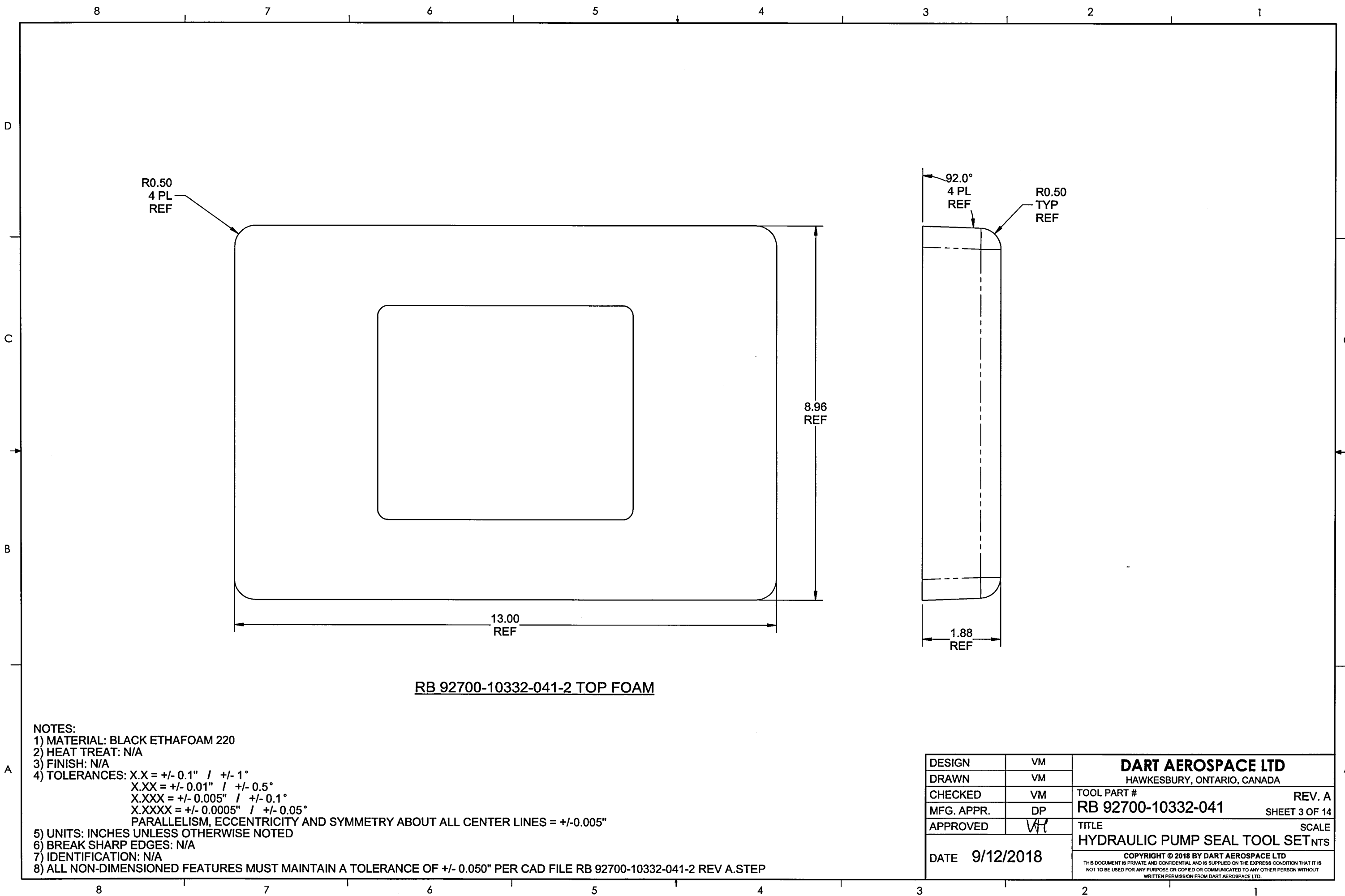
ITEM #	QTY	PART #	PART TITLE
-2	1	RB 92700-10332-041-2	TOP FOAM
-3	1	RB 92700-10332-041-3	BOTTOM FOAM
16	1	PELICAN #APP-iM2100-E	PELICAN CASE 2100



RB 92700-10332-041-1 PACKAGING ASSY

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10332-041	SHEET 2 OF 14
APPROVED	VT	TITLE	SCALE
DATE 9/12/2018		HYDRAULIC PUMP SEAL TOOL SET	NTS
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R0.50
4 PL
REF

92.0°
4 PL
REF

R0.50
TYP
REF

8.96
REF

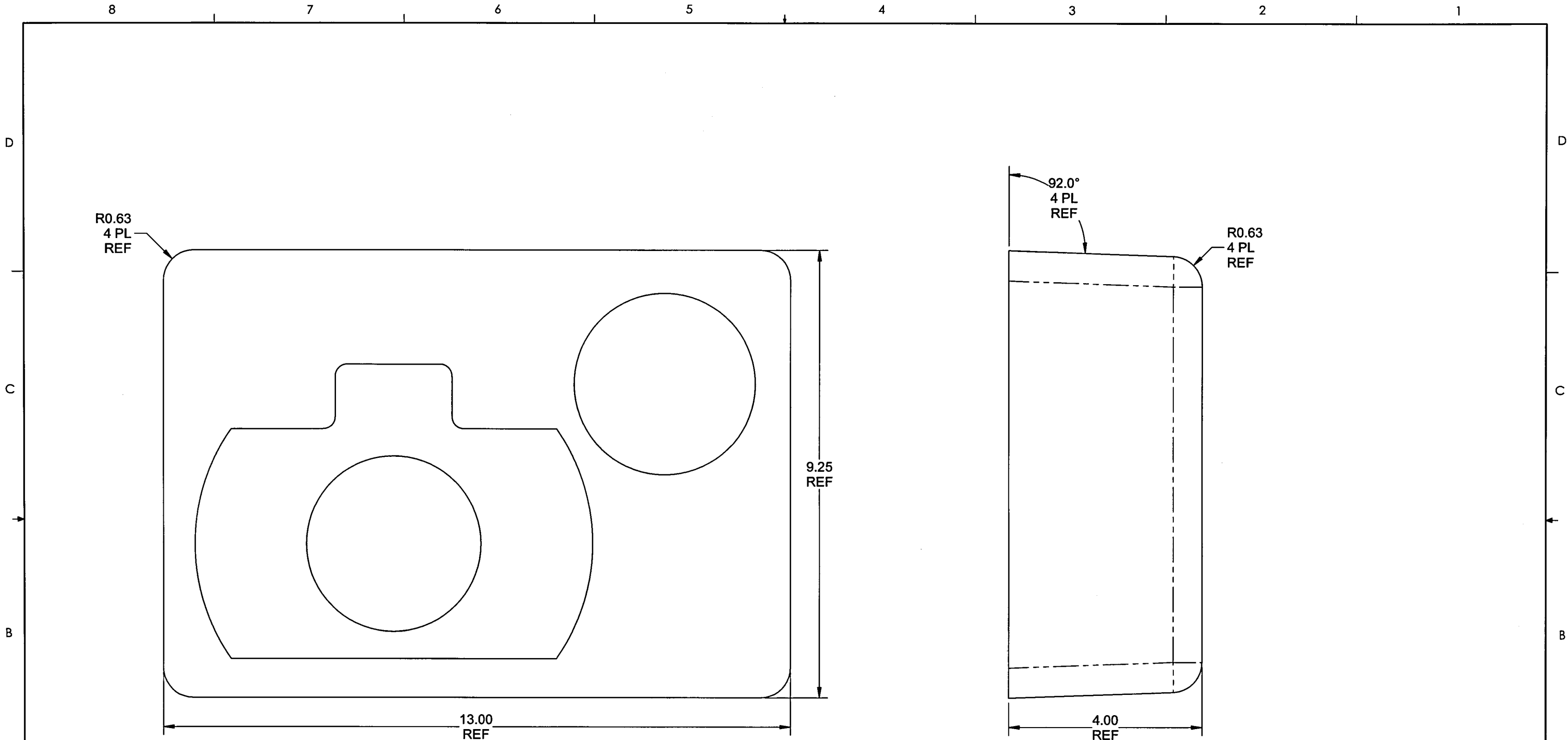
13.00
REF

1.88
REF

RB 92700-10332-041-2 TOP FOAM

- NOTES:
- 1) MATERIAL: BLACK ETHAFOAM 220
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB 92700-10332-041-2 REV A.STEP

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10332-041	SHEET 3 OF 14
APPROVED	WHT	TITLE	SCALE
DATE 9/12/2018		HYDRAULIC PUMP SEAL TOOL SET NTS	
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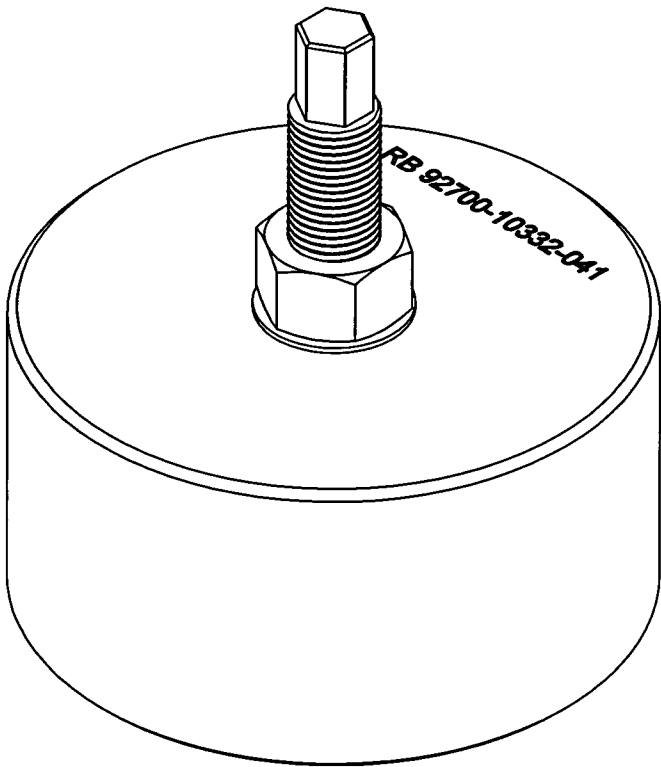
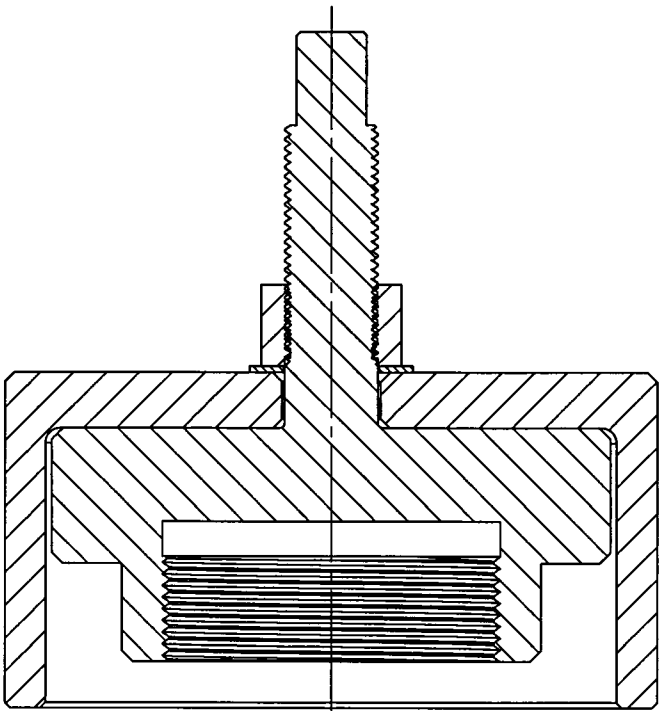
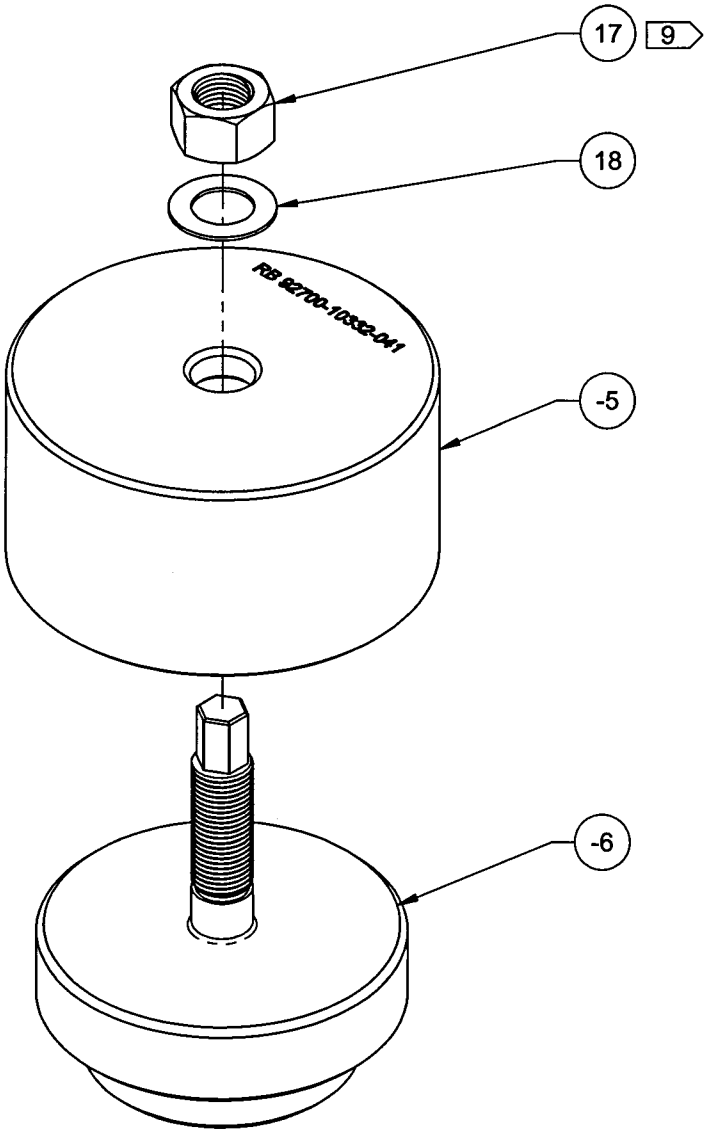


RB 92700-10332-041-3 BOTTOM FOAM

- NOTES:
- 1) MATERIAL: BLACK ETHAFOAM 220
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB 92700-10332-041-3 REV A.STEP

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10332-041	SHEET 4 OF 14
APPROVED	VM	TITLE	SCALE
DATE 9/12/2018		HYDRAULIC PUMP SEAL TOOL SET NTS	
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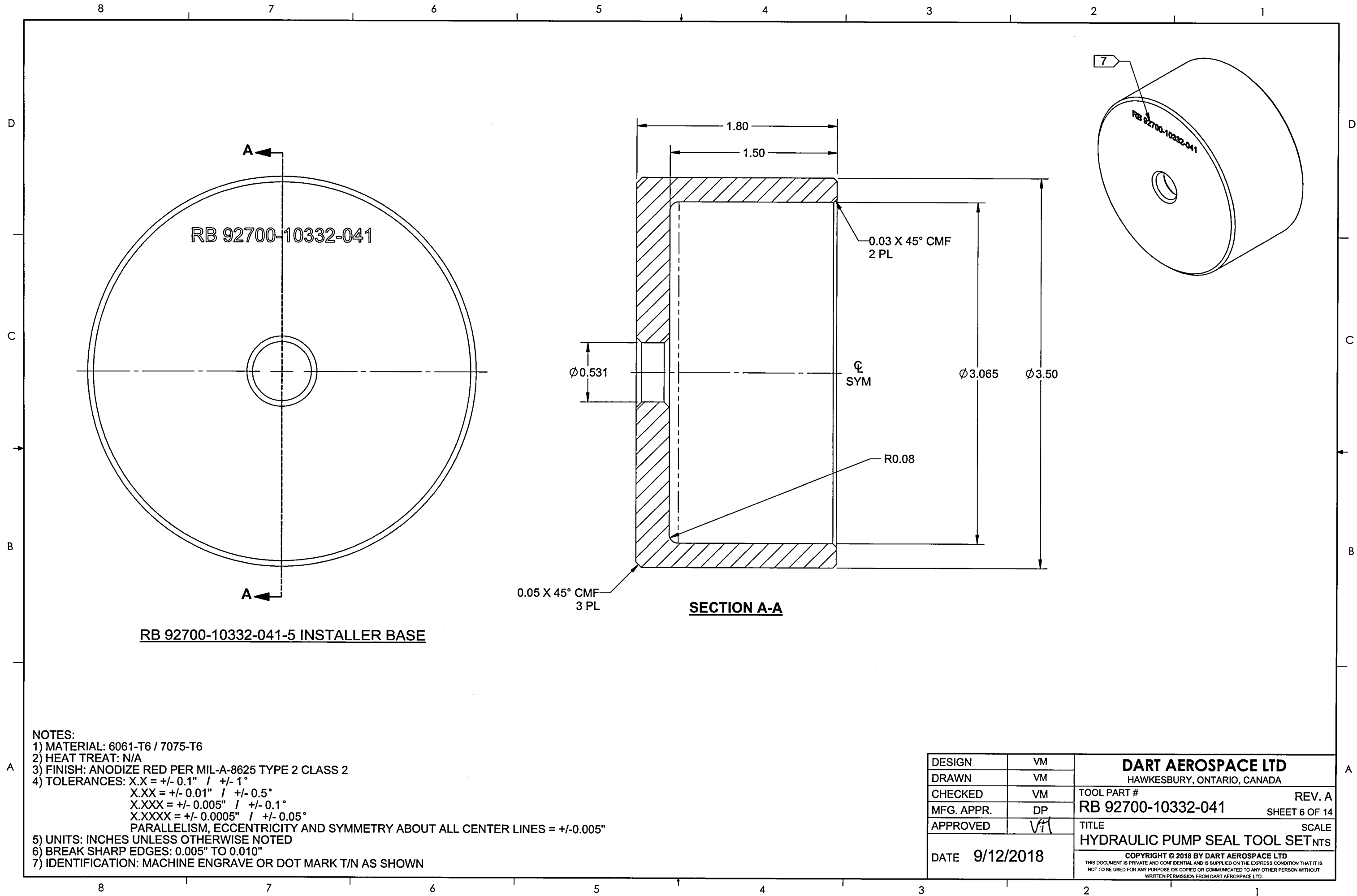
ITEM #	QTY	PART #	PART TITLE
-5	1	RB 92700-10332-041-5	INSTALLER BASE
-6	1	RB 92700-10332-041-6	INSTALLER
17	1	McMaster#94895A825 OR EQUIV	STEEL HEX NUT 1/2"-20
18	1	NAS1149F0832P	FLAT WASHER FOR 1/2" BOLT

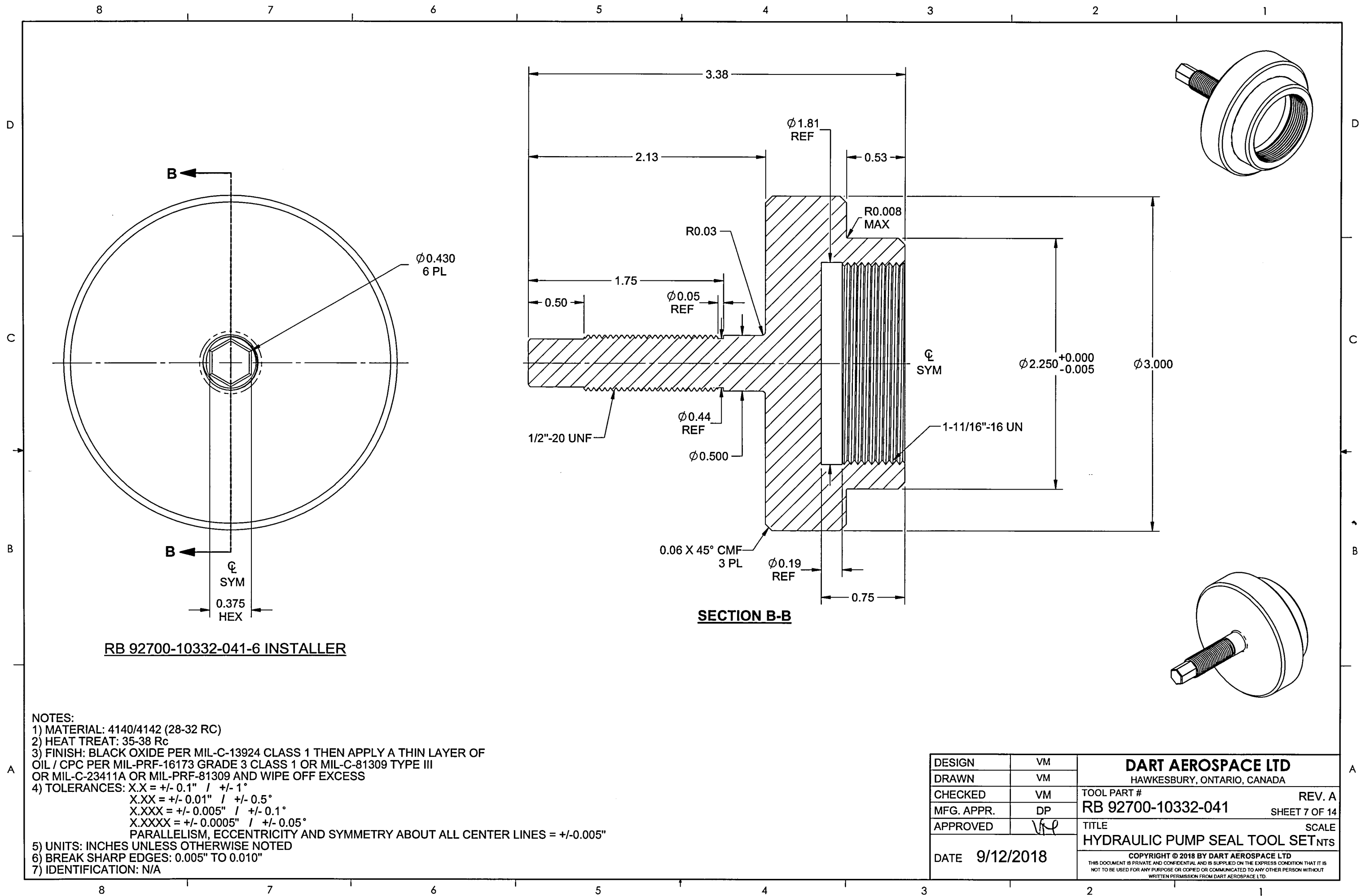


NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ASSEMBLE AS SHOWN
9) INSTALL ITEM 17 HAND TIGHT
10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

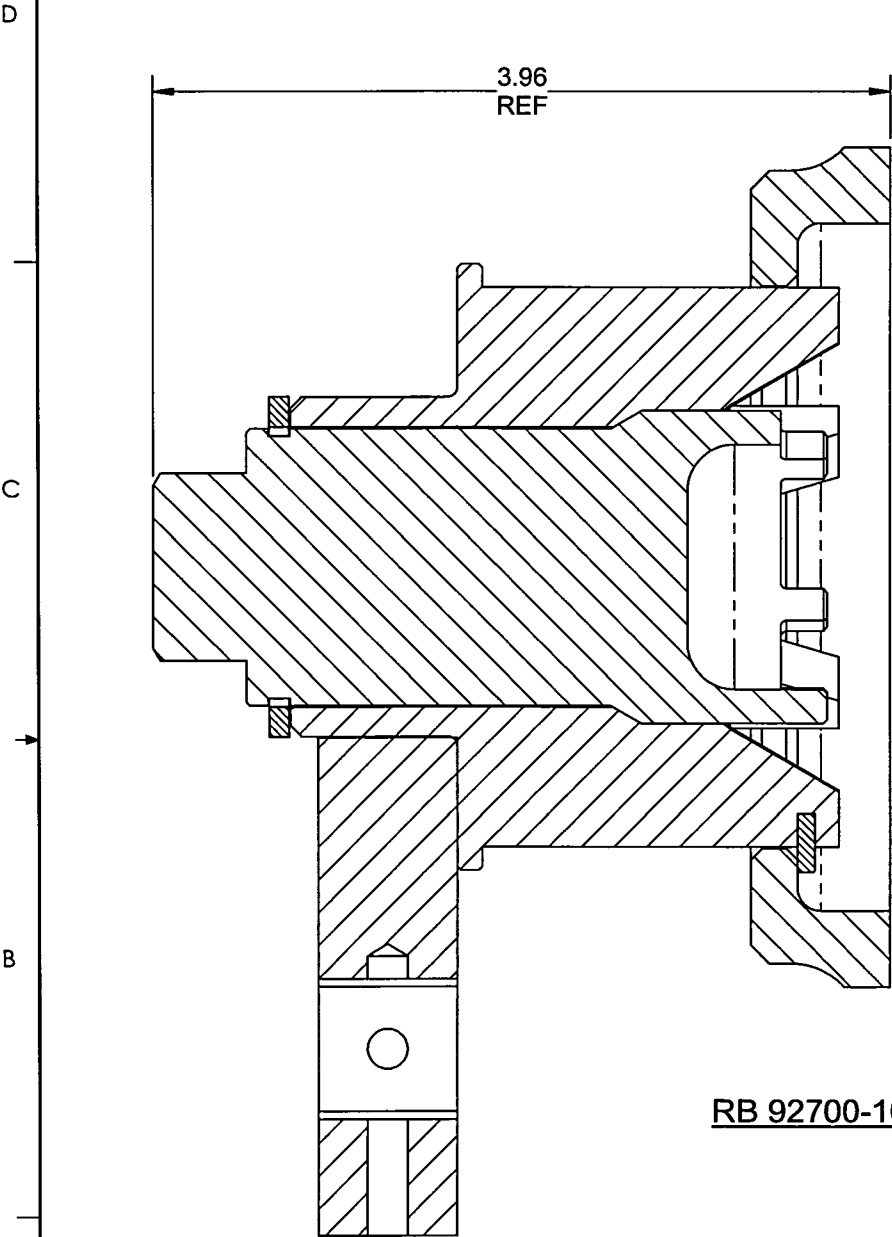
RB 92700-10332-041-4 INSTALLER ASSY

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10332-041	SHEET 5 OF 14
APPROVED	VF	TITLE	SCALE
DATE 9/12/2018		HYDRAULIC PUMP SEAL TOOL SETNTS	
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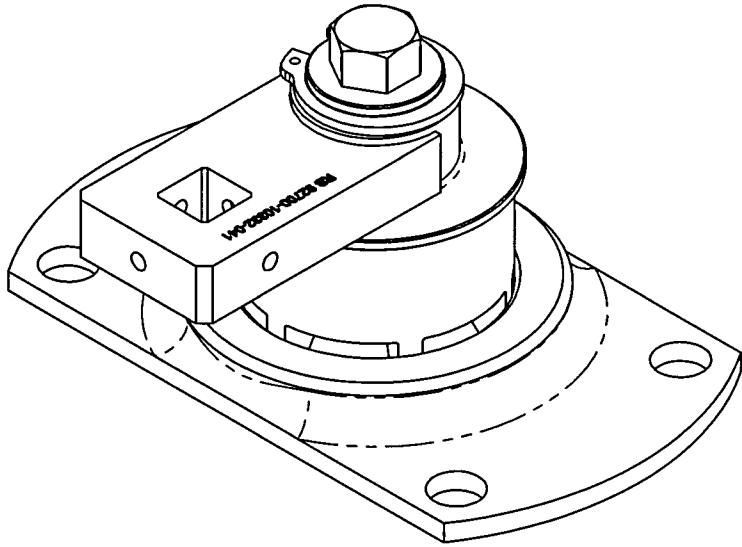
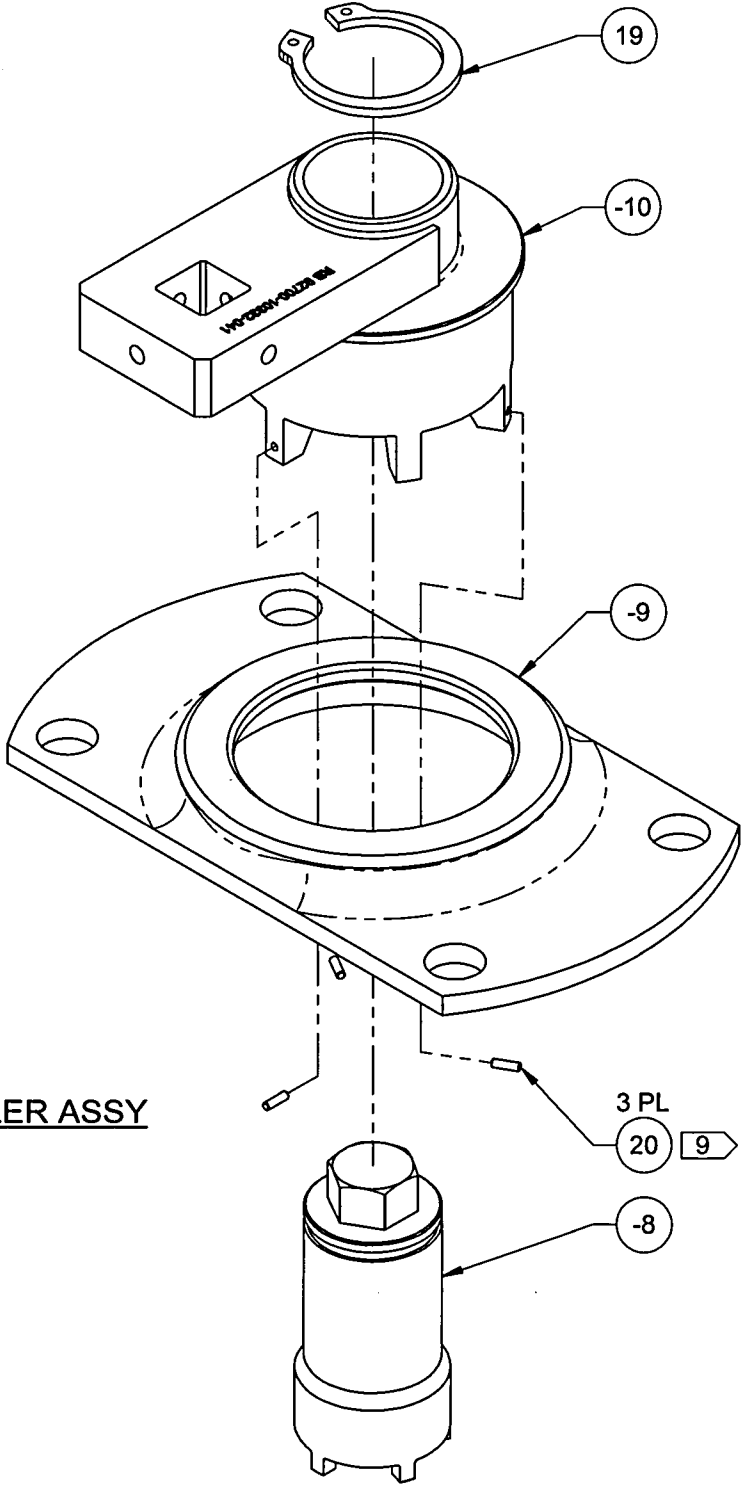


ITEM #	QTY.	PART #	PART TITLE
-8	1	RB 92700-10332-041-8	SEAL INSTALLER SOCKET
-9	1	RB 92700-10332-041-9	SEAL INSTALLER BASE
-10	1	RB 92700-10332-041-10	SEAL INSTALLER WELDMENT
19	1	McMaster#98585A133 OR EQUIV.	STEEL EXTERNAL RETAINING RING FOR 1-1/2" OD
20	3	McMaster#98380A435 OR EQUIV	SS DOWEL PIN 3/32" DIA. x 5/16" LG.



RB 92700-10332-041-7 SEAL INSTALLER ASSY

10



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 20 DOWEL PIN WITH ITEM -10 AND REMOVE EXCESS
- 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10332-041	SHEET 8 OF 14
APPROVED	VM	TITLE	SCALE
DATE 9/12/2018		HYDRAULIC PUMP SEAL TOOL SET NTS	
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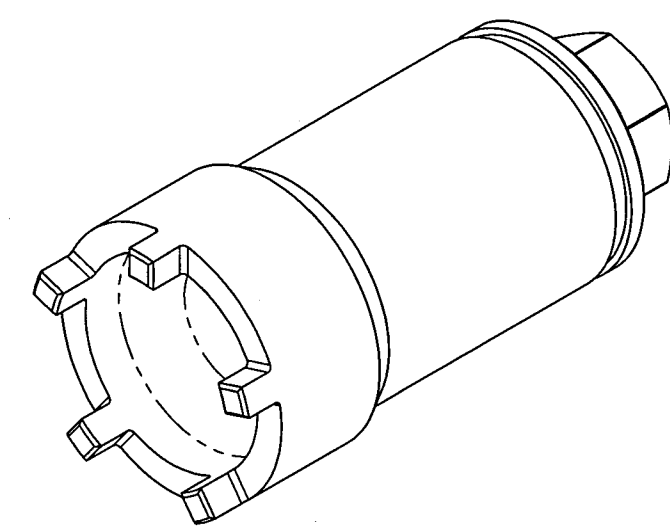
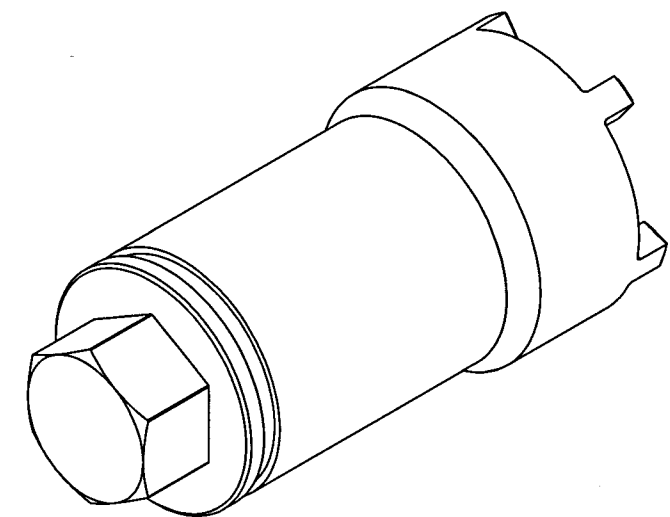
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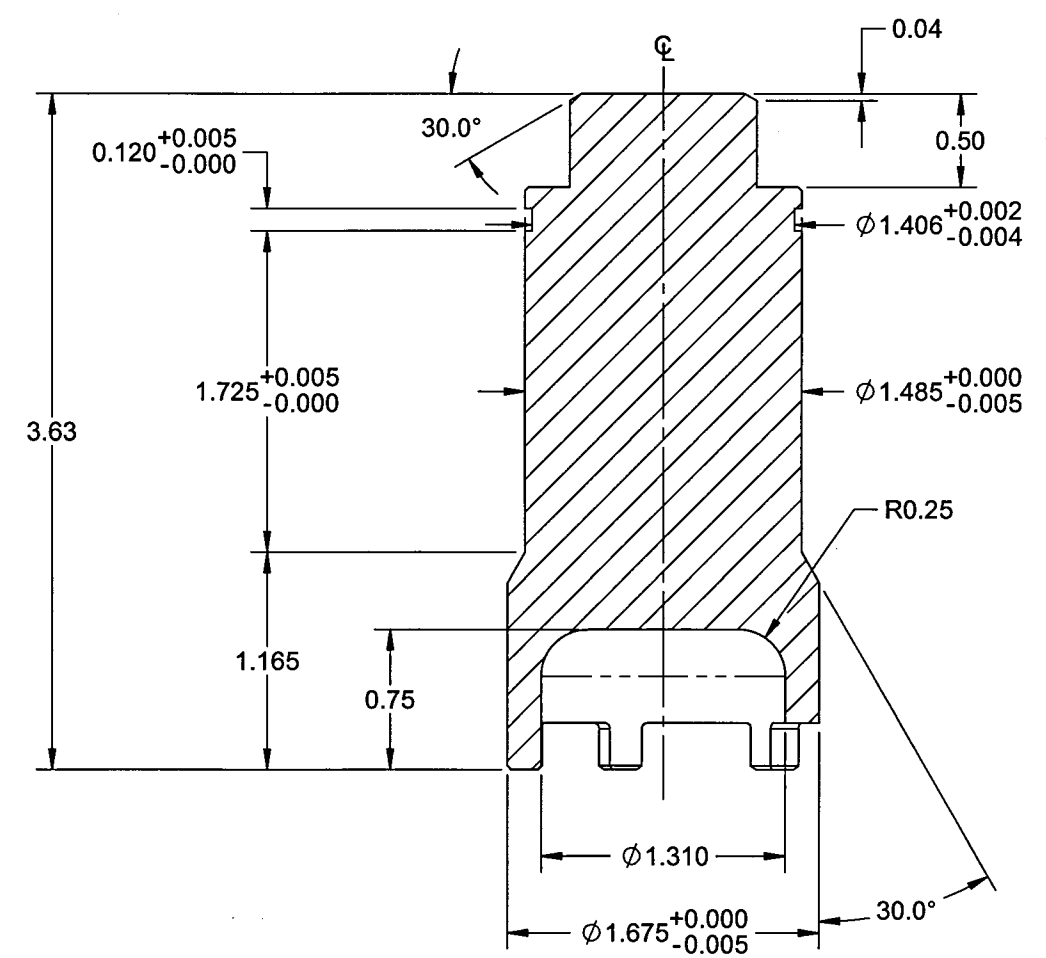
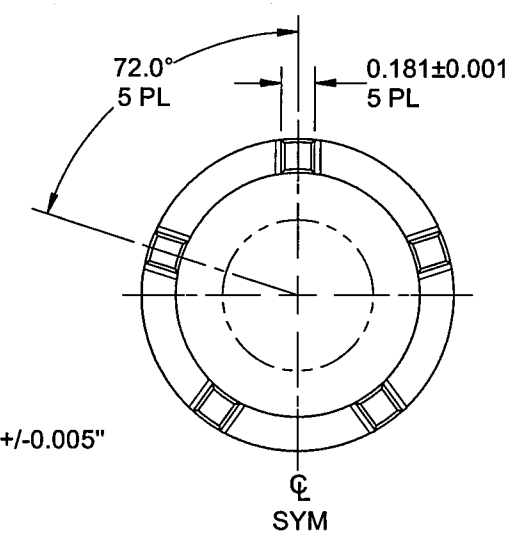
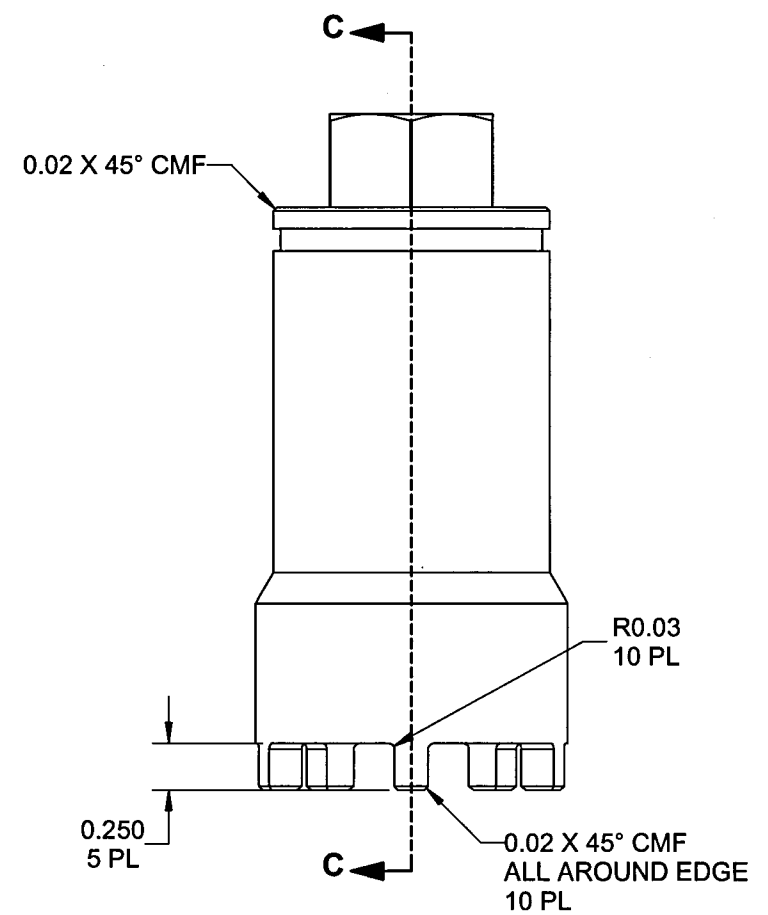
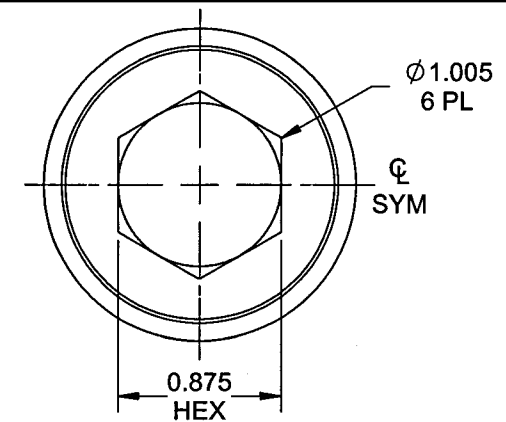
C

B

A



RB 92700-10332-041-8 SEAL INSTALLER SOCKET

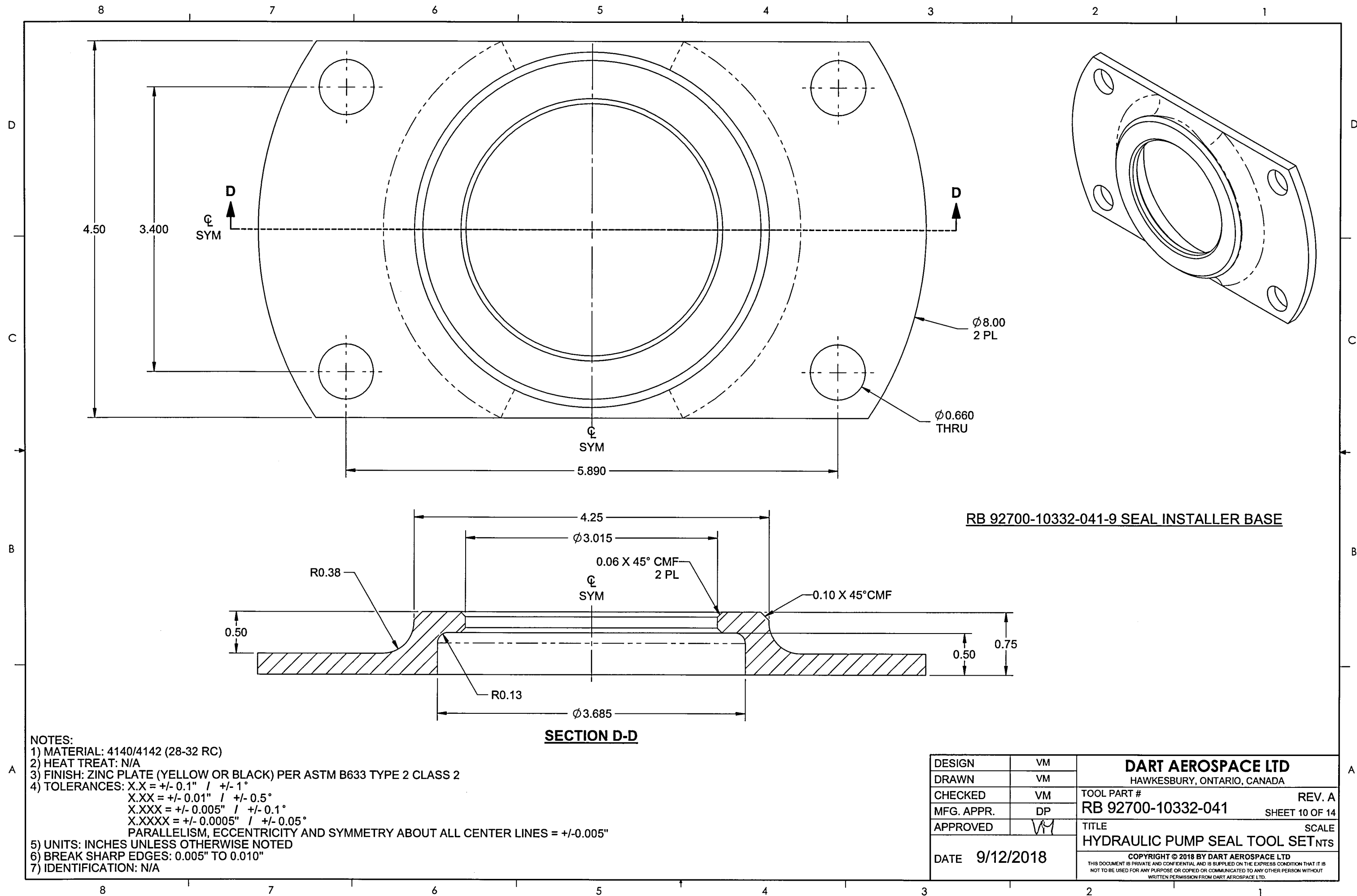


SECTION C-C

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: 35-38 Rc
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10332-041	SHEET 9 OF 14
APPROVED	VM	TITLE	SCALE
DATE 9/12/2018		HYDRAULIC PUMP SEAL TOOL SET	NTS
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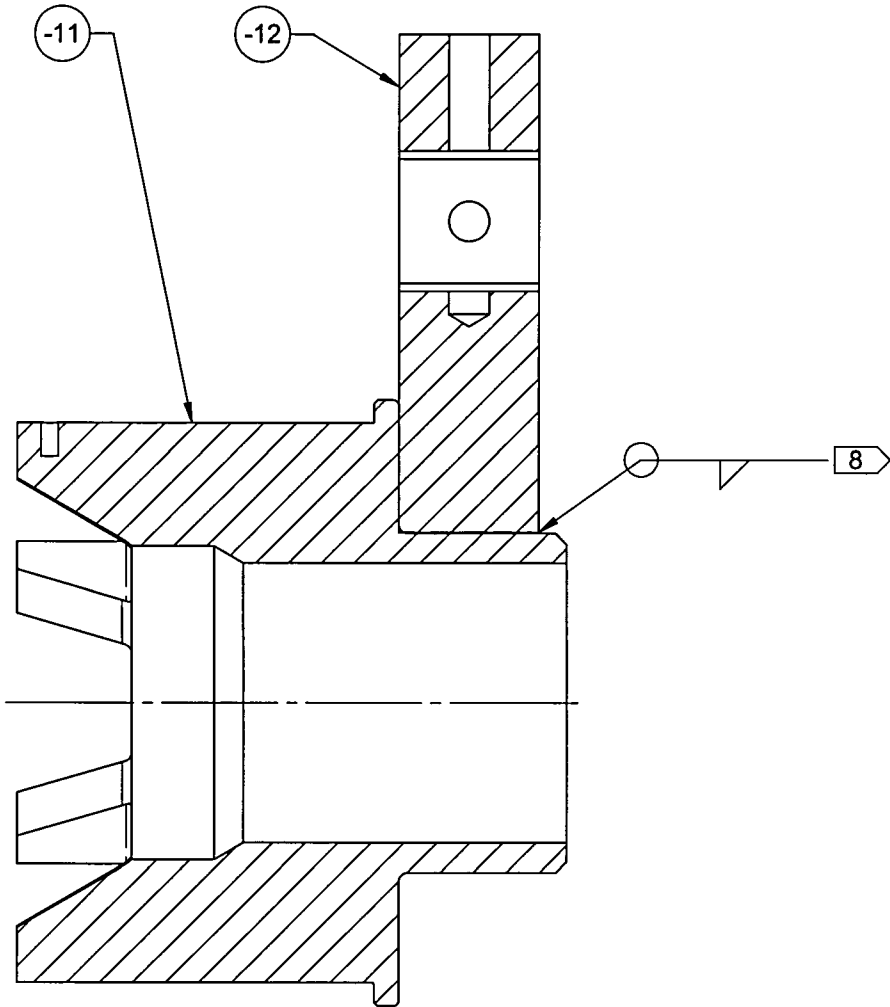
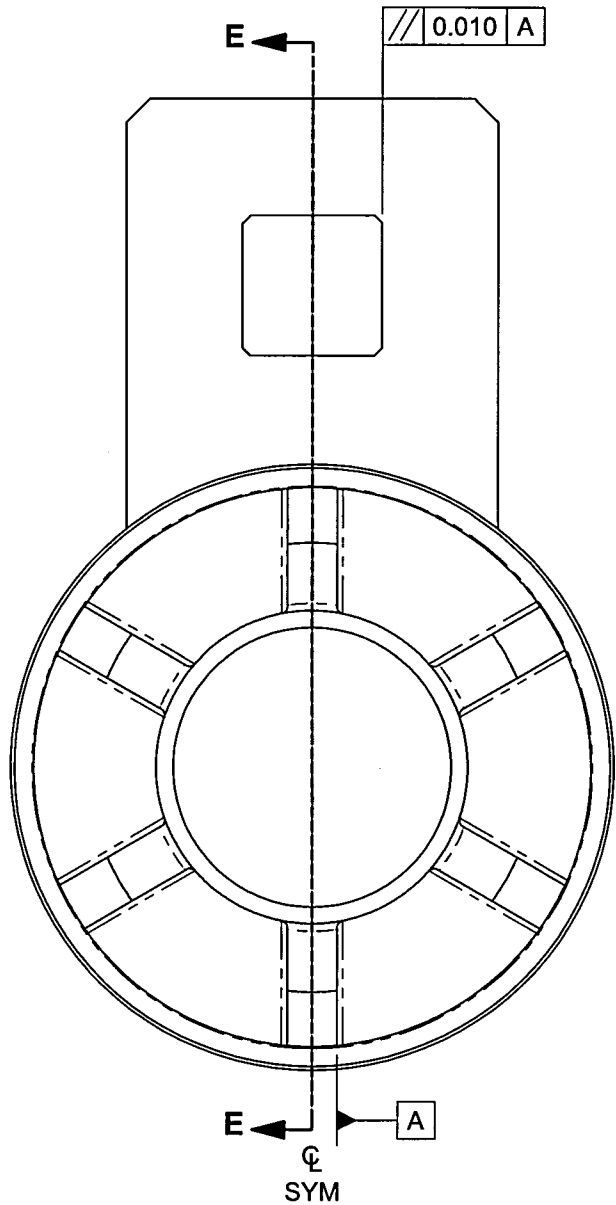
8 7 6 5 4 3 2 1



NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

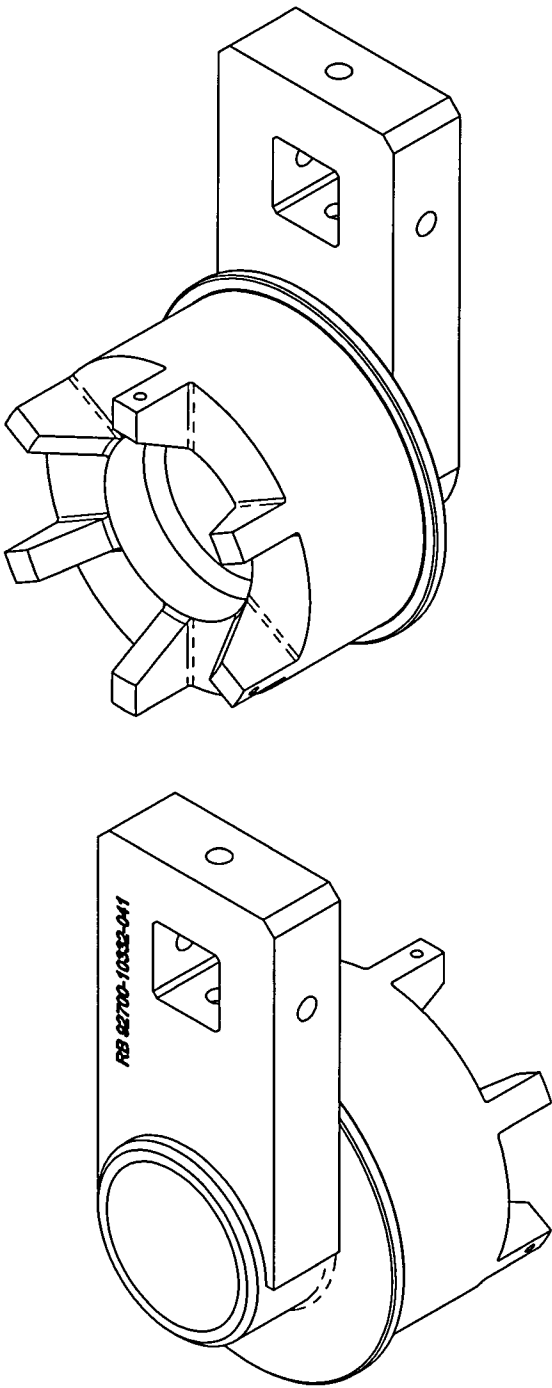
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10332-041	SHEET 10 OF 14
APPROVED	VM	TITLE	SCALE
DATE 9/12/2018		HYDRAULIC PUMP SEAL TOOL SET NTS	
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ITEM #	QTY	PART #	PART TITLE
-11	1	RB 92700-10332-041-11	SEAL INSTALLER
-12	1	RB 92700-10332-041-12	DRIVE PLATE



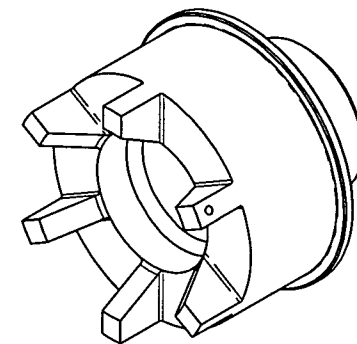
SECTION E-E

RB 92700-10332-041-10 SEAL INSTALLER WELDMENT



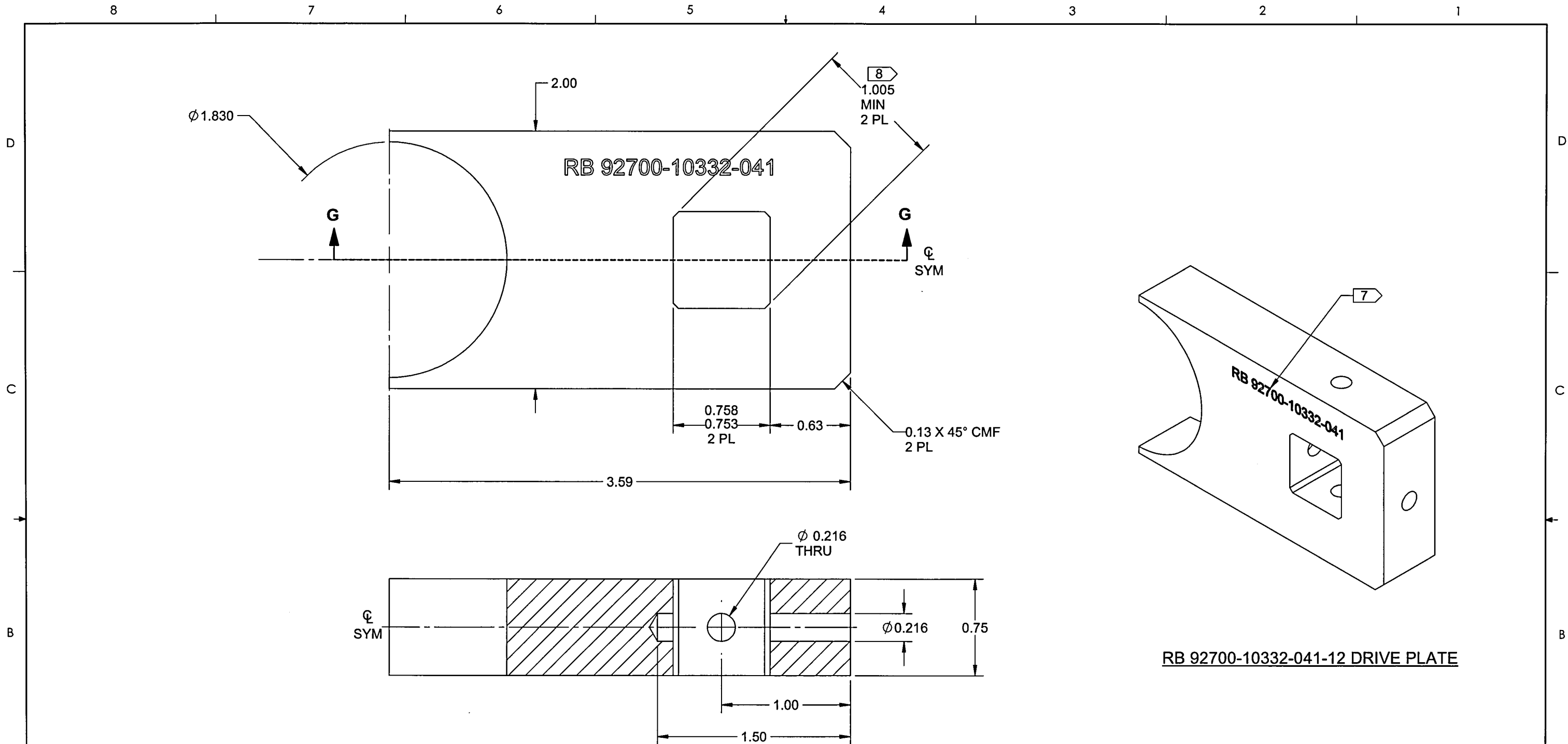
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN, ALIGN SQUARE DRIVE WITH CENTER OF TEETH

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10332-041	SHEET 11 OF 14
APPROVED	VM	TITLE	SCALE
DATE 9/12/2018		HYDRAULIC PUMP SEAL TOOL SET NTS	
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SECTION F-F

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10332-041	SHEET 12 OF 14
APPROVED	VF	TITLE	SCALE
DATE 9/12/2018		HYDRAULIC PUMP SEAL TOOL SET NTS	
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SECTION G-G

RB 92700-10332-041-12 DRIVE PLATE

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: 35-38 Rc
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN
 - 8) BROACH CORNERS CAN BE RELIEVED WITH 1/16" DRILL DIA. IF NECESSARY

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10332-041	SHEET 13 OF 14
APPROVED	VM	TITLE	SCALE
DATE 9/12/2018		HYDRAULIC PUMP SEAL TOOL SET NTS	
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